

Work Order ID 61609

Monday, August 30, 2010 1:33:49 PM

Page 1

Item ID: D412-704-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Pedal Assembly (205/212/214/412)

Start Date: 8/30/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: *[Signature]*Date: *10-8-31* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D412-704-041	Rev A
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100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble pedal as per Dwg D412-704-041
Tighten & Torque Bolts as per Dwg D412-704-041*Ep 10/08/31 (2)*

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*8w608b1**(42)*

120

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/8/31 (30) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC4- 100% Inspect kits for completeness

0.00

8/30/08/31



QC

Memo

0.00

(X2)

Quality Control

140

Identify as per dwg & Stock Location: 57/91 0.00



Packaging

Memo

0.00

Packaging

8/30/08/31(2)

150

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/09/01

MF

10-9-1

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Page 1

(b) (7)(C), (b) (7)(D)

Required Date: 9/6/2010

Required Qty: 2.00

Comments: IPP Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF
 IPP Rev:C 06.03.08 Re-format EC
 IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
 IPP Rev:E 07.05.02 Reformat EC
 IPP Rev:F 08-10-08 as per revB DD veriified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A  Bolt		Purchased	No			100	Each	47.0000	1	2		EP 10/08/31	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351				47			2		
					115016			47					
AN315-4R  Nut		Purchased	No			100	Each	60.0000	1	2		EP 10/08/31	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST324				60			2		
					17566			60					
AN4-10A  Bolt		Purchased	No			100	Each	104.0000	1	2		EP 10/08/31	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST356				104			2		
					113422			4					
					114523			100					

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Picklist Print

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Work Order ID: 61609

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

AN4-12A



Bolt

Purchased No

100 Each

323.0000

2

4



8/30/08/31

4

Location

Loc Qty

Loc Code

ST357

323

112314

123

115371

40

115422

160

AN4-13A



Bolt

Purchased No

100 Each

740.0000

1



8/30/08/31

2

Location

Loc Qty

Loc Code

ST357

240

115108

240

ST358

500

115159

500

AN960JD10

NAS1149D0363J

Purchased No

100 Each

6.0000

5

10



Washer

40 M115107 (105)



8/30/08/31

Location

Loc Qty

Loc Code

ST

6

107715

6

AN960JD416

NAS1149D0463J

Purchased No

100 Each

0.0000

11

22



Washer

40 M115000 (224)



8/30/08/31

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

AN960JD416L NAS1149D0416J Purchased No
Washer *M115107 (6x)*

100 Each 309.0000 3 6

Location

Loc Qty

Loc Code

ST346

309

106785

60

110153

249

Ep 50/08/31

D3204-041
Release Pedal Assembly

Manufactured No

100 Each 2.0000 1 2

Location

Loc Qty

Loc Code

ST197

2

57457

2

Ep 50/08/31

D3205-1
Pedal Bracket

Manufactured No

100 Each 6.0000 1 2

Location

Loc Qty

Loc Code

ST197

6

55731

6

Ep 50/08/31

D3205-3
Back Plate

Manufactured No

100 Each 8.0000 1 2

Location

Loc Qty

Loc Code

ST197

8

47491

8

Ep 50/08/31

D3206-1
Pedal Arm

Manufactured No

100 Each 11.0000 1 2

Location

Loc Qty

Loc Code

ST197

11

55732

11

Ep 50/08/31
855763 (20)

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID: 61609

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

D3209-041



Bracket Assembly

Manufactured No

100 Each

7.0000

1



2
8/30/08/31

Location

Loc Qty

Loc Code

ST045

3

58265

3

ST202

4

60295

4

2
8/30/08/31

MS21042L3



Nut

Purchased No

100 Each

2,174.000

1



2
8/30/08/31

Location

Loc Qty

Loc Code

ST300

2174

114523

115

114718

59

114784

2000

2
8/30/08/31

MS21042L4



Nut

Purchased No

100 Each

2,535.000

5



10
8/30/08/31

Location

Loc Qty

Loc Code

ST300

2535

112314

12

113422

68

114523

28

114718

16

114784

491

115108

1920

10
8/30/08/31

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 61609

Parent Item: D412-704-041

Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

MS24694-S102

Purchased

No

100

Each

58.0000

1



Screw

Location

Loc Qty

Loc Code

ST288

50

114382

50

ST289A

8

113644

8

MS9519-10

Purchased

No

100

Each

38.0000

1



Bolt

Location

Loc Qty

Loc Code

ST297

38

100290

38

AN3-6A

Purchased

No

120

Each

270.0000

2



Bolt

Location

Loc Qty

Loc Code

ST351

270

113359

70

114941

200

AN960JD10L

NAS1149D0332J

Purchased

No

120

Each

2,479.000

4



Washer

Location

Loc Qty

Loc Code

ST348

2479

110985

2479

2
8/30/08/31

2
8/30/08/31

2
4
10/8/31 SP

4
8
10/8/31 SP (20)

8

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Parent Item Name: Pedal Assembly (205/212/214/412)



Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

120

Each

2,174.000

1

4



10/8/31

2x SP

S Nut
#2

Location

Loc Qty

Loc Code

ST300

2174

114523

115

114718

59

114784

2000

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

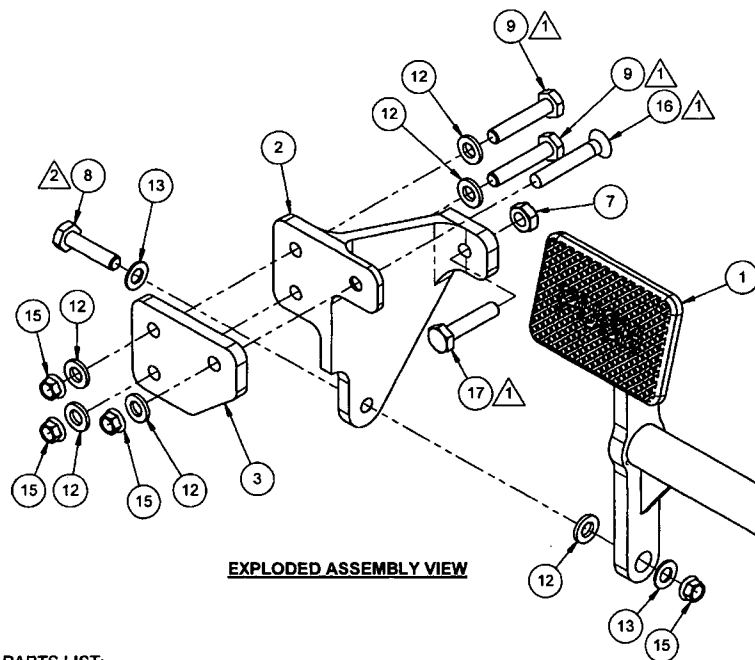
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

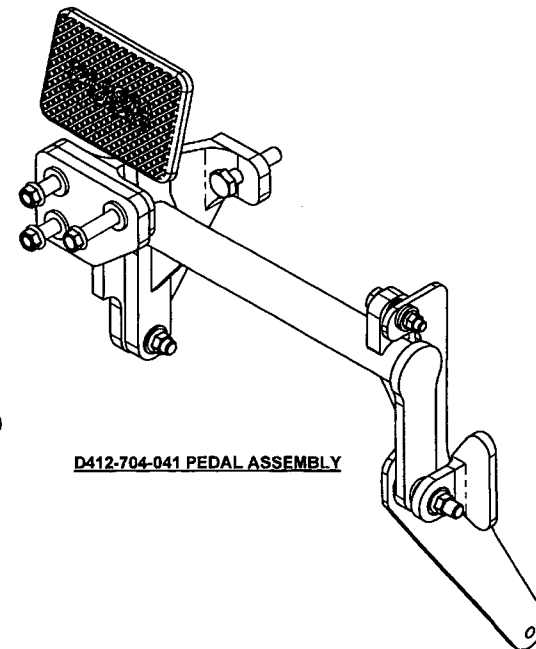
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SHOP COPY
RETURN TO
ENGINEER'S
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *44609*
2810-8-30



EXPLODED ASSEMBLY VIEW



D412-704-041 PEDAL ASSEMBLY

PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

- 1 INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2 TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3 TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

RELEASED

07.01.30

A	REV	DATE	NEW ISSUE	DESCRIPTION
DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	LE	APPROVED	[Signature]	DRAWING NO. D412-704-041
DATE	07.01.23	TITLE	PEDAL ASSEMBLY	REV. A SHEET 1 OF 1 SCALE 1:2

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